






Tapered burr Ø2.3 Z25 with radius

A11-011

The tapered burr Ø2.3mm is ground from a solid carbide blank. The requested geometry of all 25 teeth is achieved with a 1V1 wheel.



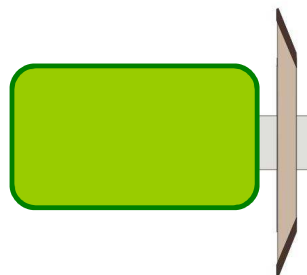
1. Cycletime for Production

Workpiece: Diameter 2.3 mm, Z 25, L14 mm, Helix angle 15° Material CARBIDE			
Operations			
	Probe	Flute 1	Flute 2
Feed [mm/Min]	2000	200	200
Power [kW]		3	2
Cutting speed [m/s]		32	32
Used wheels		 1	 1
Grinding time [s]	6	202	202
Total cycle time	6 Min 50		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø60 D64
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3. Machine and Software Requirements

Machines:	5 axes CNC grinder : Aries5	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:			
Responsible engineer:	SIW. 05.13		

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